

Date: Monday, 6/26/2006 3:46:46 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET BASE ASS'Y (A119)
Job Number : 27693B	
Estimate Number : 12431	
P.O. Number : NIA	Part Number : D3516041
This Issue : 6/26/2006 S.O. No. : NIA	Drawing Number : D3516 PRELIMINARY
Prsht Rev. : NC	Project Number : N/A
First Issue : NIA Type : LARGE FAB ASSY	Drawing Revision : PRELIMINARY
Previous Run : NIA	Material : NIA
Written By : SEE COMMENT BELOW	Due Date : 7/3/2006 Qty: 1 Um: Each
Checked & Approved By : [Signature]	
Comment : EST rev. A 06.05.31 Preliminary EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D34421	Shim
-----	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Shim

Batch: 826920



2.0	D2581	Mounting Bracket
-----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

Batch: 826204



8262

3.0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer Bushing

Batch: 825823



4.0	D22323	Basket Hinge
-----	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Batch: 825239



5.0	D35169	RIB
-----	--------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

RIB

Batch: 826717



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/26/2006 3:46:46 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSY (A119)

Job Number: 27693B

Part Number: D3516041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 53.1825 f(s)/Unit Total : 53.1825 f(s)

AISI 304 SQ Tube.75x.75x.065W

Batch: ~~1160703~~ 1160703

AD

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut rib D3516-1 as per dwg D3516

2-Cut rib D3516-3 as per dwg D3516

3-Cut rib D3516-5 as per dwg D3516

4-Cut rib D3516-7 as per dwg D3516

AD

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3516

AD

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD

10.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 60.0000 sf(s)/Unit Total : 60.0000 sf(s)

Expanded Metal Flat Stainless steel

Batch: 1160999

AD

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut expanded metal for base as per dwg D3516

2-Cut expanded metal for base ends as per dwg D3516

3-Weld expanded metal to base as per dwg D3516

AD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/07/24

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/26/2006 3:46:47 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASS'Y (A119)

Job Number: 27693B

Part Number: D3516041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5/9

WELD INSPECTION



PD

Comment: WELD INSPECTION

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M 107266 28 (1)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3515 and QSI 005 4.4

M 107266 Spray: M101242 M Box 28 (1)

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PD

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.20

Job Completion



W 26.07.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

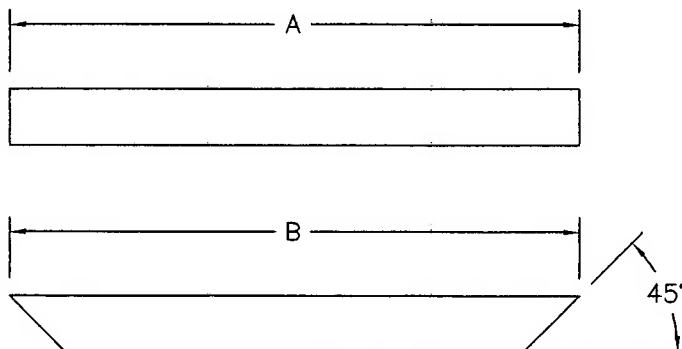
QA: N/C Closed: _____ Date: _____

PRELIMINARY ISSUE

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3516	REV. A SHEET 1 OF 4
DATE 06.06.21		TITLE BASKET BASE ASSEMBLY (A119)	SCALE NTS
A	06.06.21	NEW ISSUE	

PARTS LIST FOR D3516-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3516-1	2	—	102.00	RIB
D3516-3	2	—	25.50	RIB
D3516-5	8	26.75	—	RIB
D3516-7	3	45.50	—	RIB
D3516-9	4	N/A	N/A	RIB
D3516-11	10	N/A	N/A	CLEVIS
D2232-3	2	N/A	N/A	HINGE PLATE
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRKT
D3442-1	2	N/A	N/A	SHIM



NOTES:

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
(REF. DART SPEC. M304TS0.750W.065)
- 3) MESH MATERIAL: 3/4-16F EXPANDED SS
(REF. DART SPEC. M304EX0.75-16F)
- 4) WELD PER DART QSI 004
- 5) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

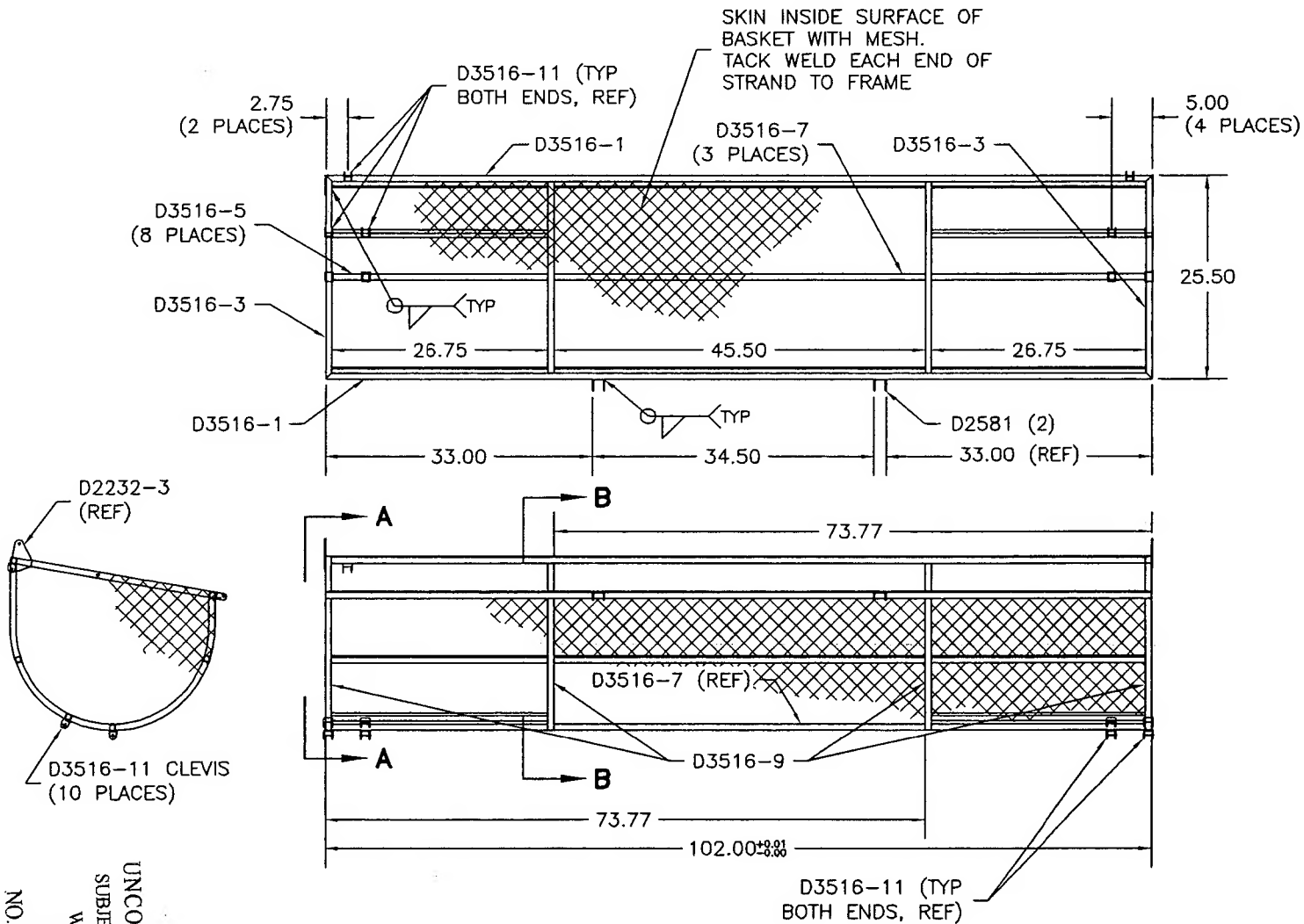
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WORK ORDER
NO. **27693B**

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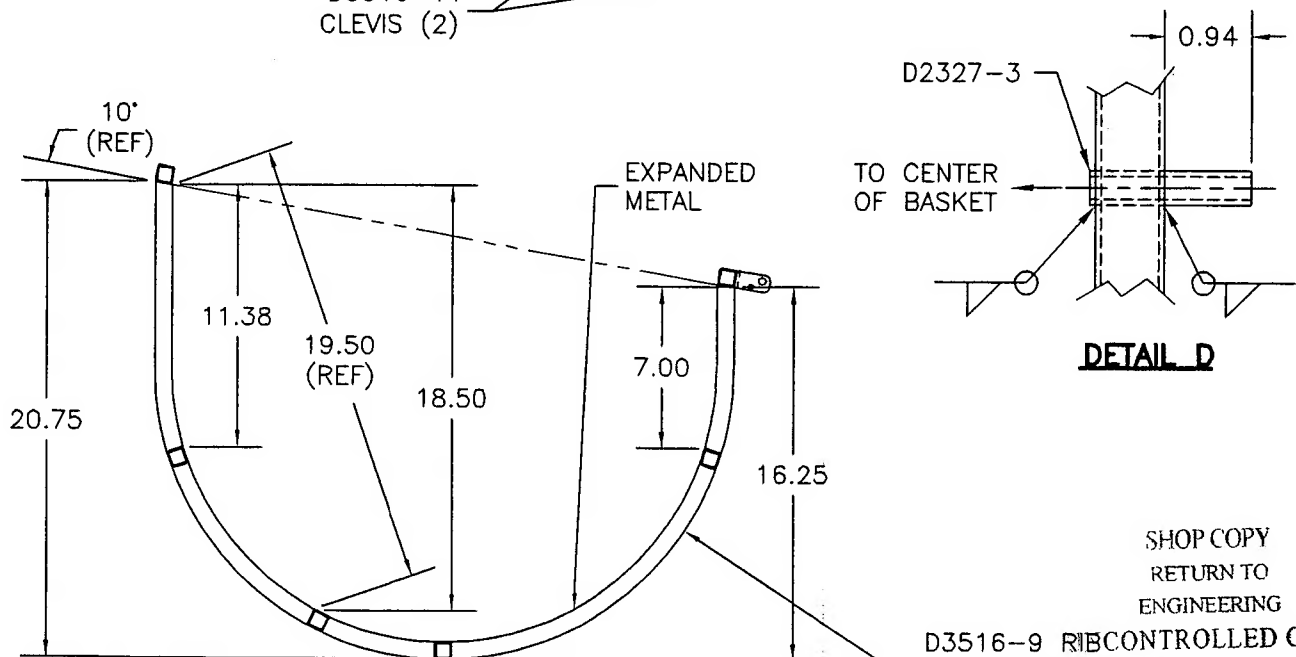
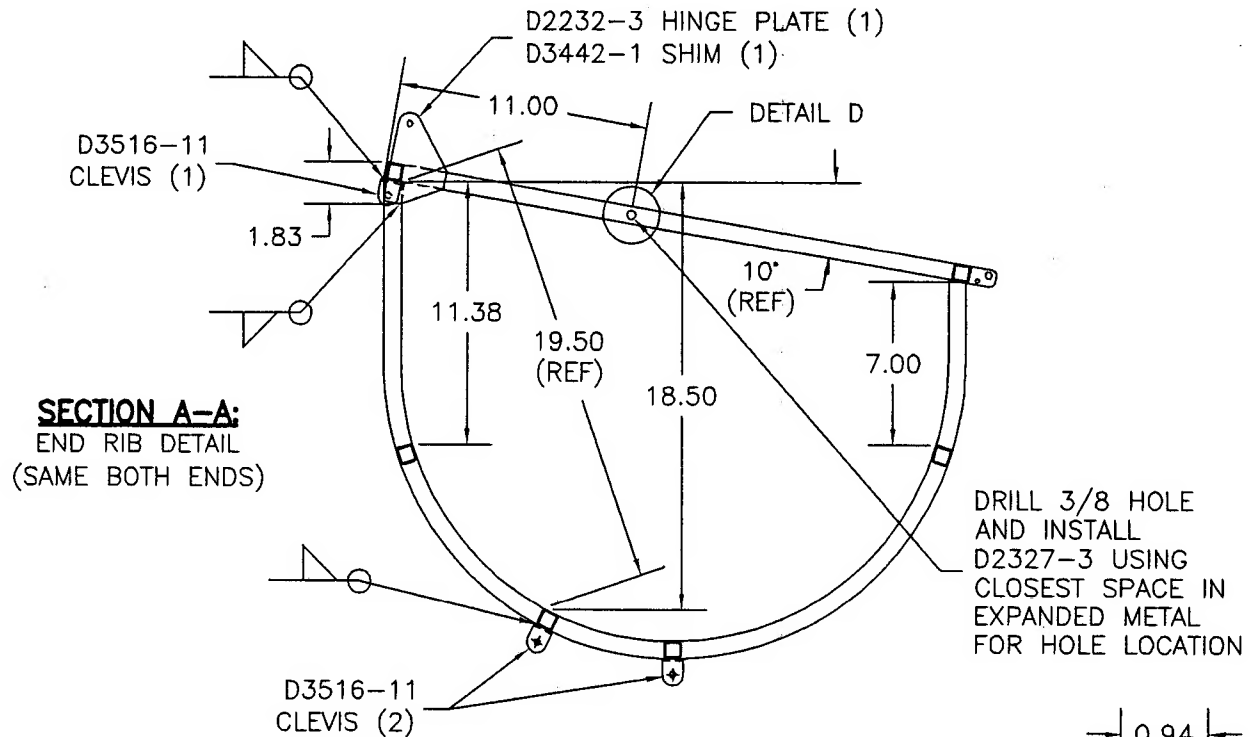
DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. A
CHECKED	APPROVED	DRAWING NO. D3516	SHEET 2 OF 4
DATE	TITLE	BASKET BASE ASSEMBLY (A119)	SCALE
06.06.21			1:20



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WORK ORDER
NO 276933

PRELIMINARY ISSUE

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CHECKED	APPROVED	DRAWING NO. D3516	REV. A SHEET 3 OF 4
DATE 06.06.21		TITLE BASKET BASE ASSEMBLY (A119)	SCALE 1:8



SECTION B-B:
CENTER RIB DETAIL
(2 PLACES)

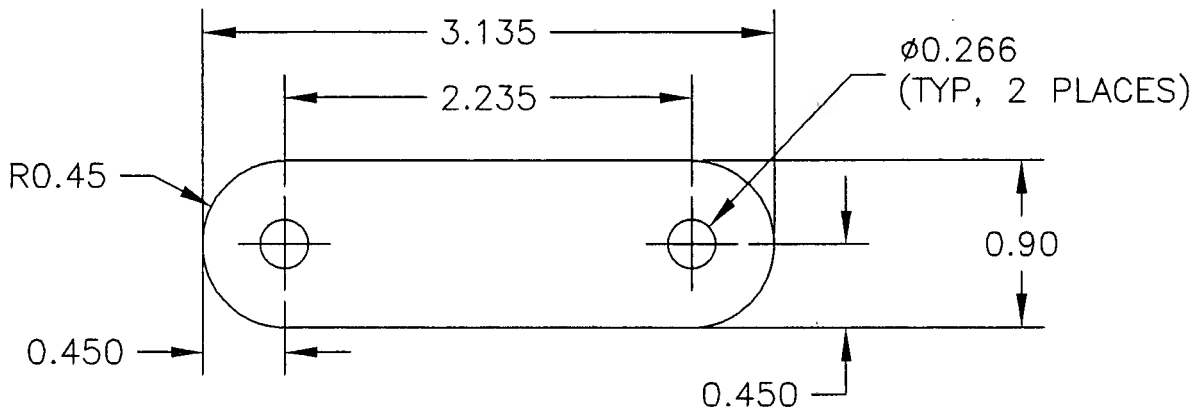
SHOP COPY
RETURN TO
ENGINEERING
D3516-9 RIB CONTROLLED COPY
(MAKE FROM D2235-8) BY AMENDMENT
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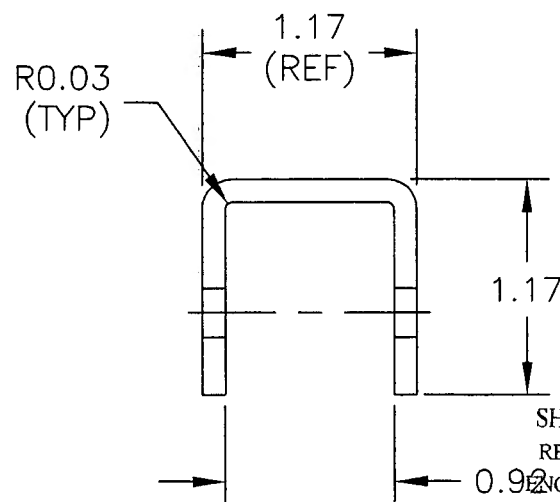
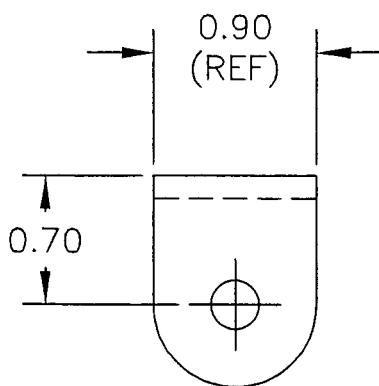
PRELIMINARY ISSUE

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CHECKED	APPROVED	DRAWING NO. D3516	REV. A SHEET 4 OF 4
DATE 06.06.21		TITLE BASKET BASE ASSEMBLY (A119)	SCALE 1:1



D3516-11F CLEVIS FLAT PATTERN

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)



D3516-11 CLEVIS BENDING DETAIL

- 1) MATERIAL: MAKE FROM D3516-11F
2) ALL DIMENSIONS ARE IN INCHES
3) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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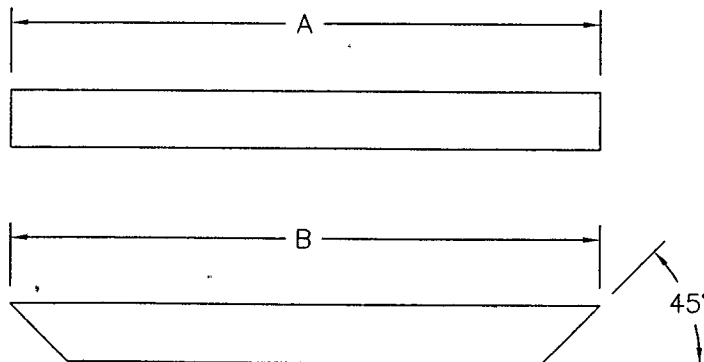
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3516	REV. A SHEET 1 OF 3
DATE 06.05.08		TITLE BASKET BASE ASSEMBLY (A119) SCALE NTS	
A	06.05.08	NEW ISSUE	

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
06-05-08 *[Signature]*

PARTS LIST FOR D3516-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3516-1	2	—	102.00	RIB
D3516-3	2	—	25.50	RIB
D3516-5	6	26.75	—	RIB
D3516-7	3	45.50	—	RIB
D3516-9	4	N/A	N/A	RIB
D2327-3	2	N/A	N/A	BUSHING
D2232-3	2	N/A	N/A	HINGE PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



NOTES:




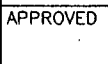
- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
- 3) MESH MATERIAL: 3/4-16F EXPANDED SS
- 4) WELD PER DART QSI 004
- 5) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

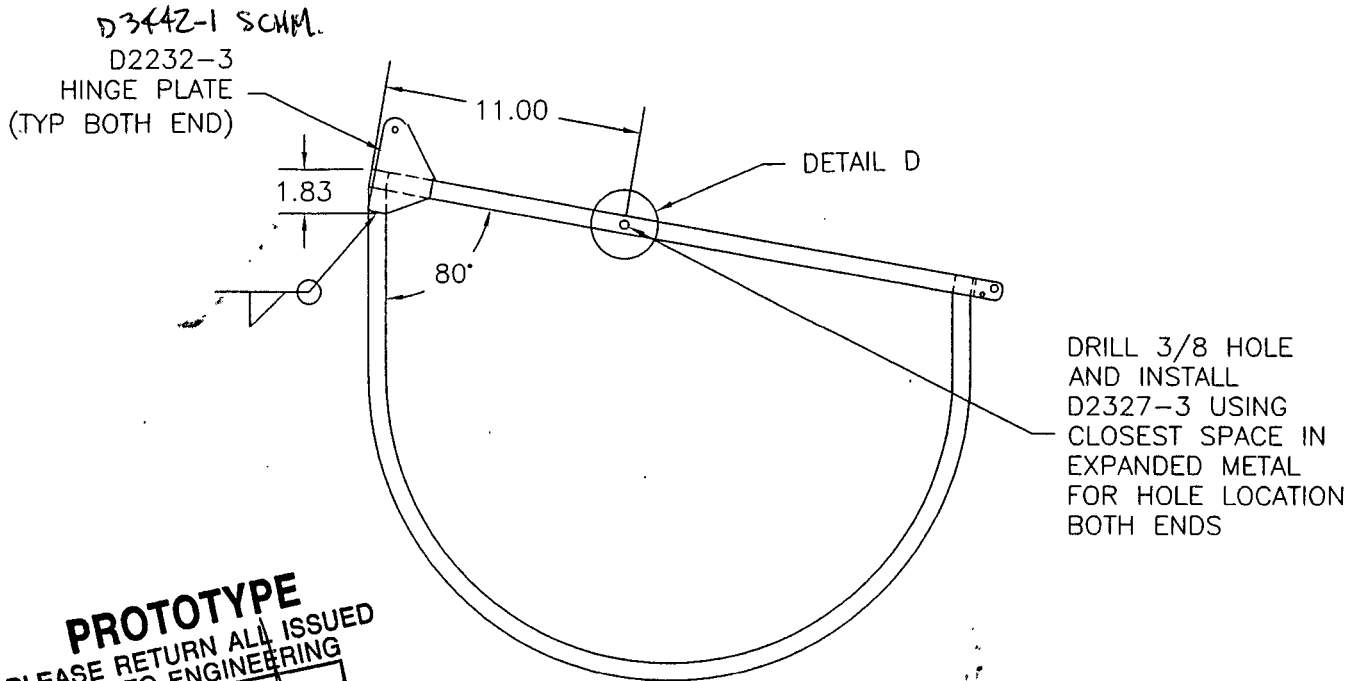
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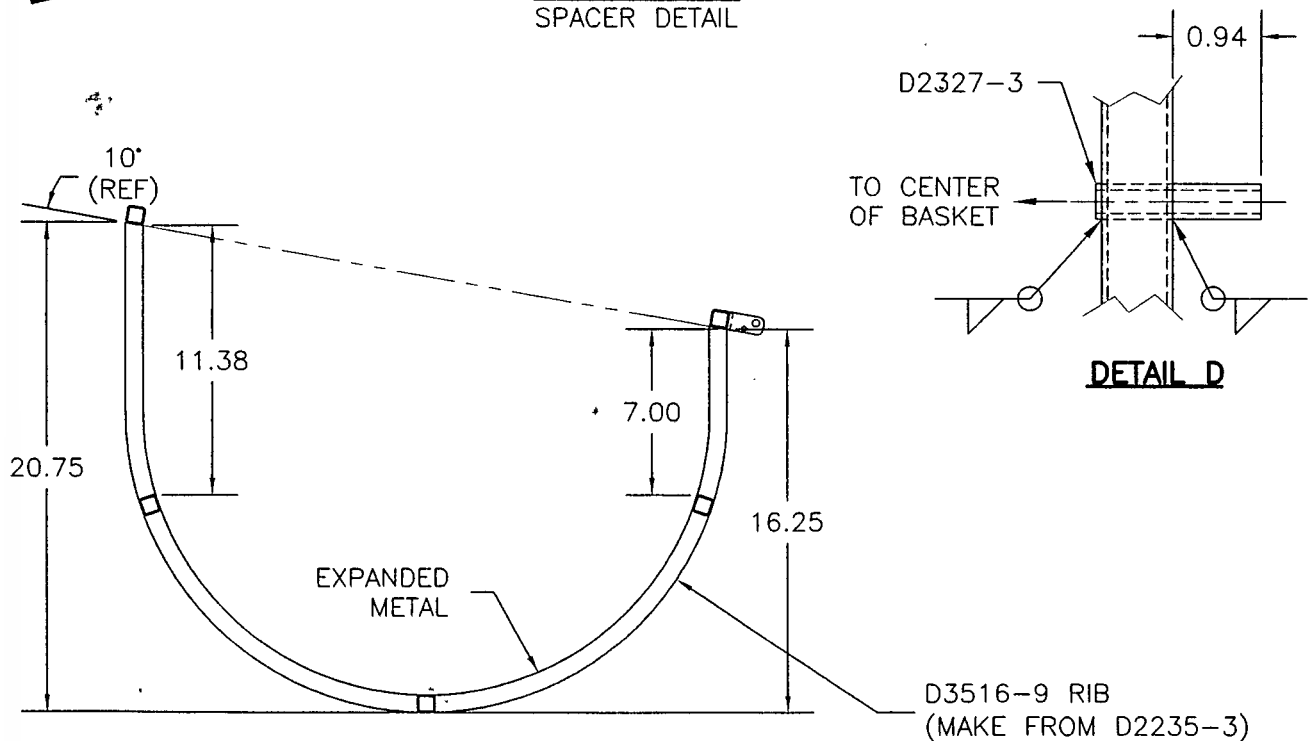
B26520

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CHECKED 	APPROVED 	DRAWING NO. D3516	REV. A SHEET 3 OF 3
DATE 06.05.08		TITLE BASKET BASE ASSEMBLY (A119)	SCALE 1:8



PROTOTYPE
PLEASE RETURN ALL ISSUED
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06-05-08

SECTION A-A:
SPACER DETAIL



SECTION B-B AND SECTION C-C:
RIB DETAIL

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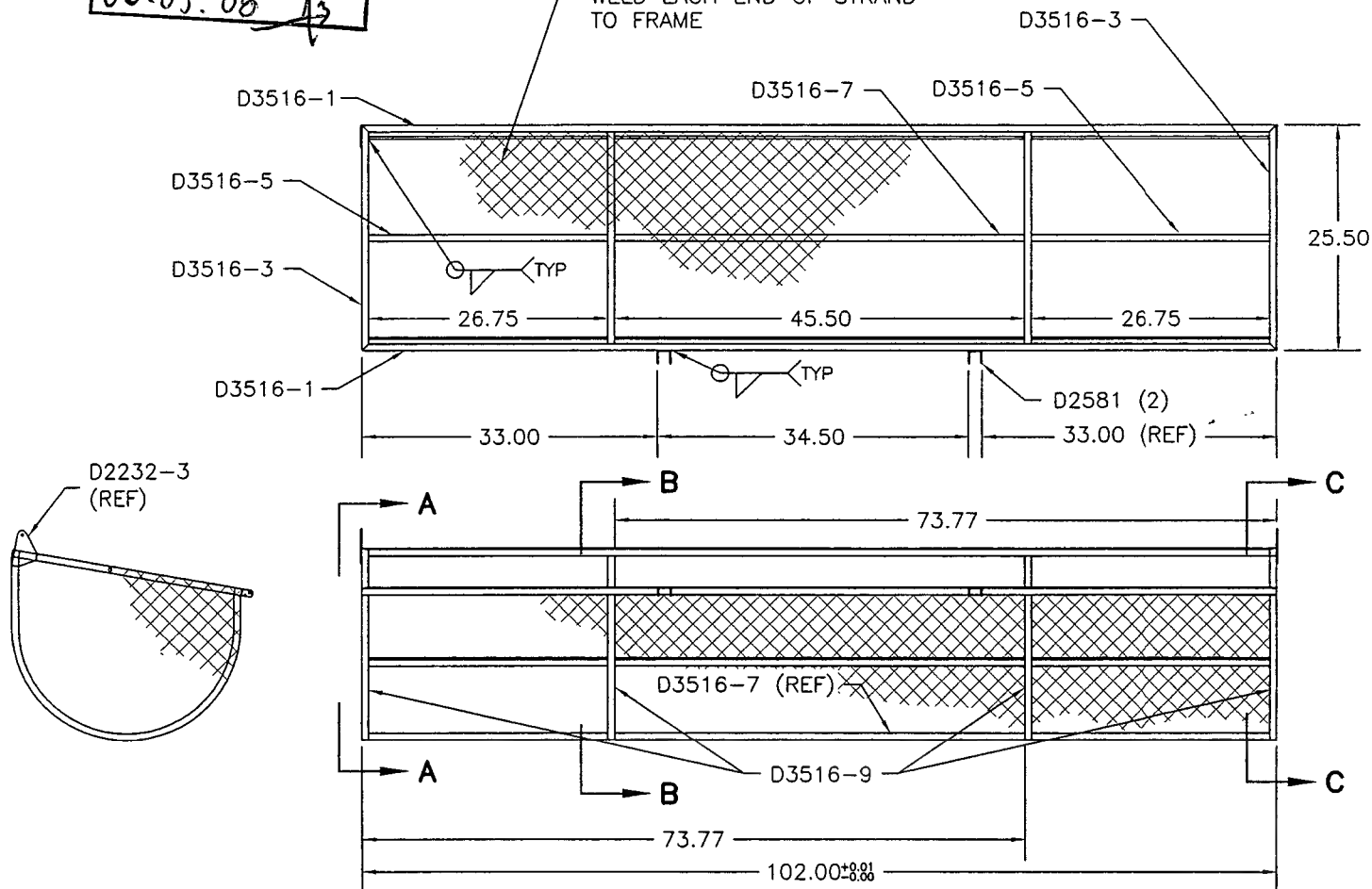
PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. A
06.05.08	D3516	SHEET 2 OF 3
	TITLE	SCALE
	BASKET BASE ASSEMBLY (A119)	1:20

PROTOTYPE
PLEASE RETURN ALL ISSUED
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06-05-08

SKIN INSIDE SURFACE OF
BASKET WITH MESH. TACK
WELD EACH END OF STRAND
TO FRAME



D3516 BASKET BASE ASSEMBLY

MESH MATERIAL: 3/4-16F EXPANDED SS
FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2)
PER DART QSI 005 4.3

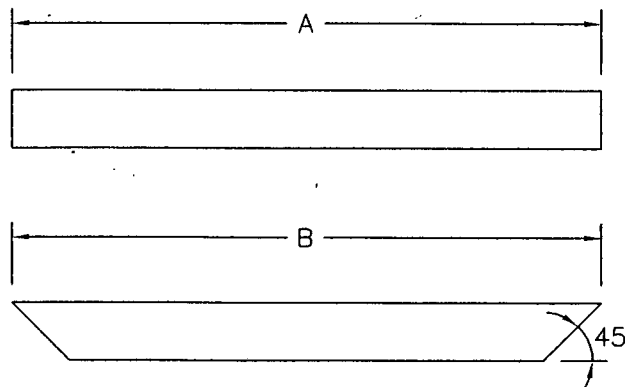
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3515	REV. A SHEET 1 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE NTS
A	06.05.05	NEW ISSUE	

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
06.05.08 *[Signature]*

PARTS LIST FOR D3515 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3515-1	2	_____	25.50	RIB
D3515-3	2	_____	101.30	RIB
D3515-5	6	32.25 33.50	_____	RIB
D3515-7	3	33.80 34.90	_____	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



D3515-1/-3/-5/-7

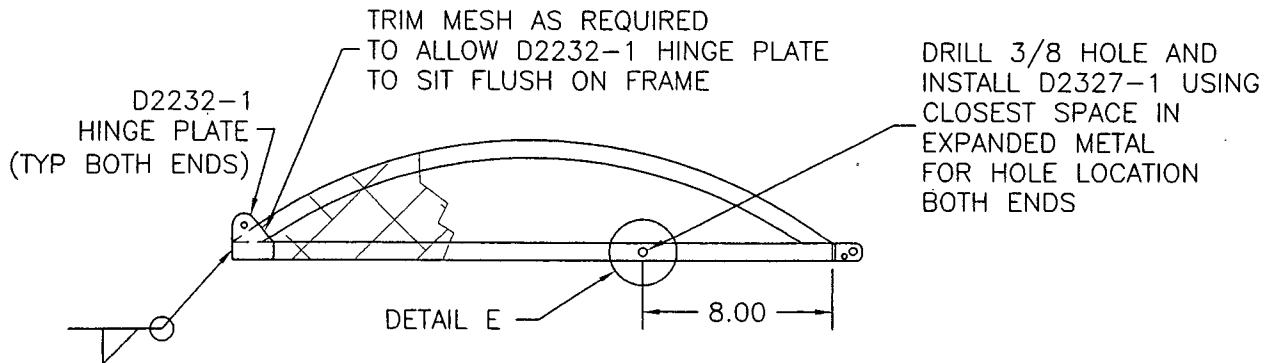
CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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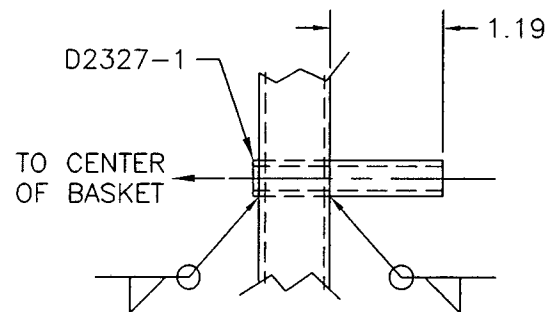
PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3516	REV. A SHEET 4 OF 4
DATE 06.05.05	TITLE BASKET LID ASSEMBLY (A119)		SCALE 1:8

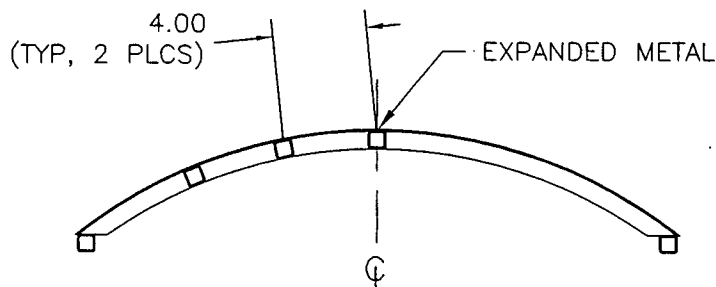


SECTION C-C SIMILIAR BOTH END RIBS

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
06.05.08



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

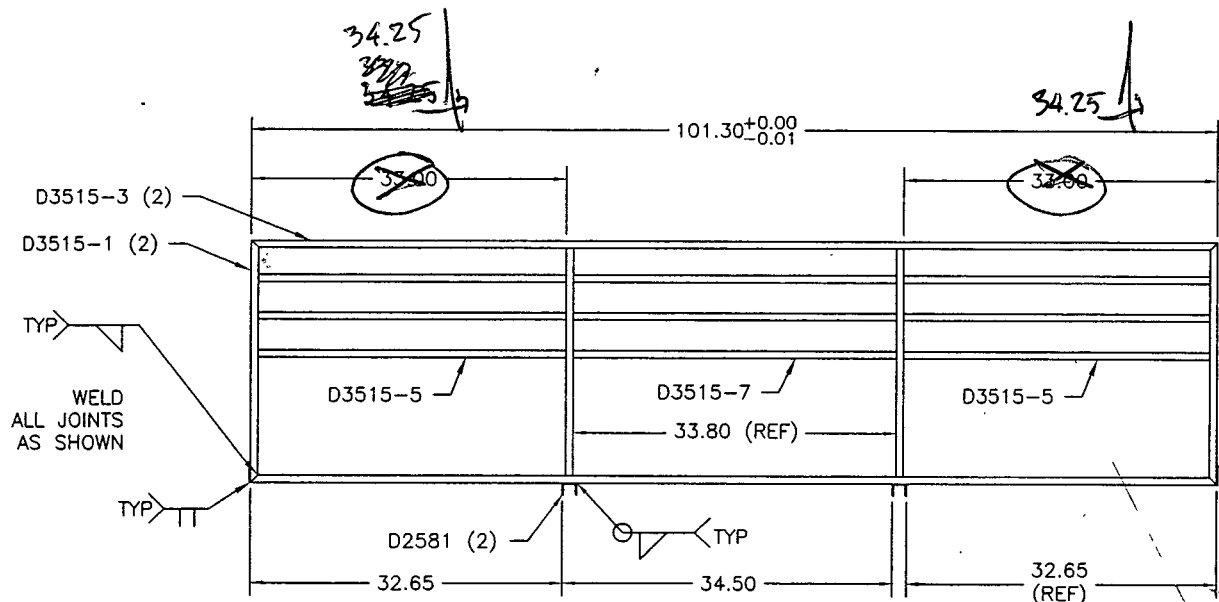
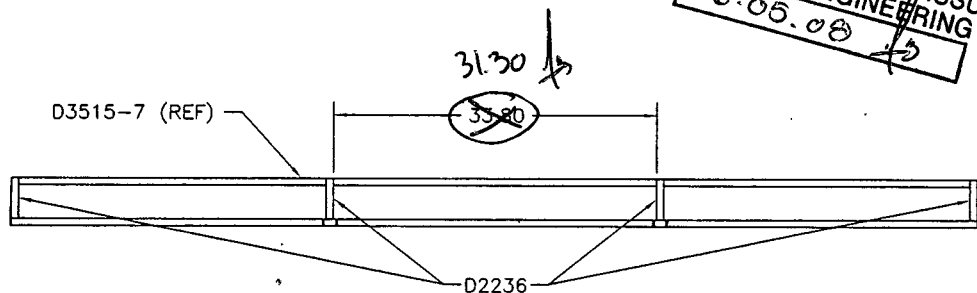
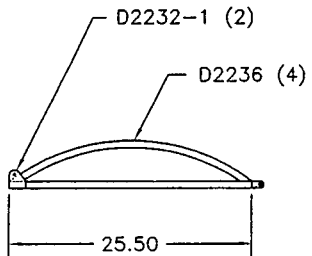
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DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE	TITLE	DRAWING NO.	REV. A
06.05.05	BASKET LID ASSEMBLY (A119)	D3515	SHEET 3 OF 4
			SCALE 1:20

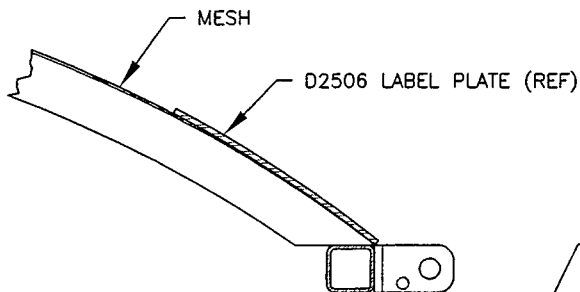


DETAIL B

FRAMEWORK SHOWN FOR CLARITY
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 ALL DIMENSIONS ARE IN INCHES

PRELIMINARY ISSUE

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
06-05-08

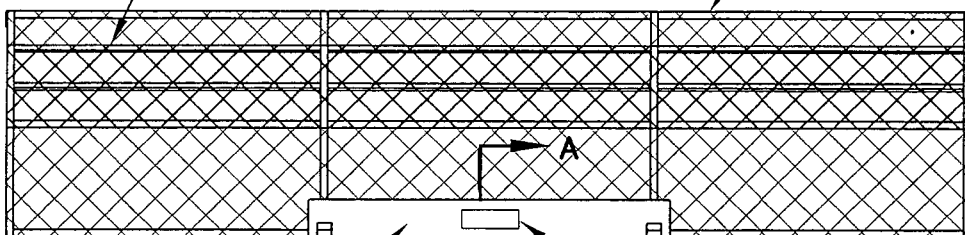


SECTION A-A (ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

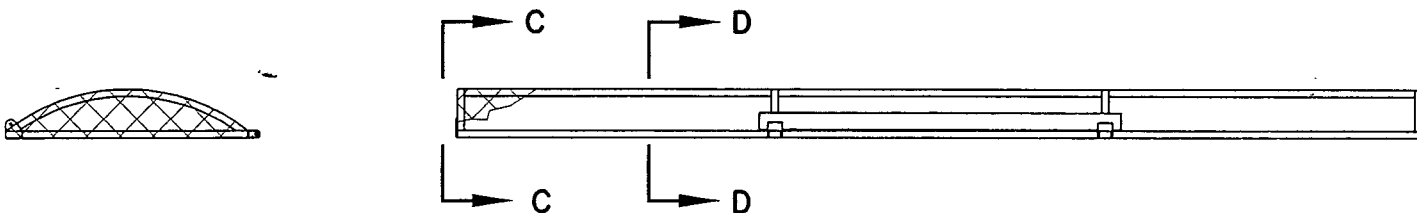
SKIN OUTSIDE SURFACE OF LID WITH
3/4-16F EXPANDED SS. TACK WELD
EACH END STRAND TO FRAME

SEE DETAIL B FOR
FRAME ASSEMBLY



D2506 LABEL PLATE
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION
OF MESH FROM BEHIND
LABEL PLATE



D2512 BASKET LID ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. A
06.05.05	D3515	SHEET 2 OF 4
	TITLE	SCALE
	BASKET LID ASSEMBLY (A119)	1:20

Mast. $\frac{3}{4} \times \frac{3}{4}$ S.S tube M 100783

$\Delta 3442-1$	SHim	B26920	Qty 2
$\Delta 2581$	mounting bracket	B26204	Qty 4
$\Delta 2232-3$	Hinge	B25239	Qty 2
$\Delta 2232-1$	Hinge	B25238	Qty 2
$\Delta 2327-3$	Bushing	B25823	Qty 2
$\Delta 2327-1$	Bushing	B24873	Qty 2
$\Delta 3166-1$	Rid	B26717	Qty 4
$\Delta 3166-3$	Hoop	B25896 B25896	Qty 1

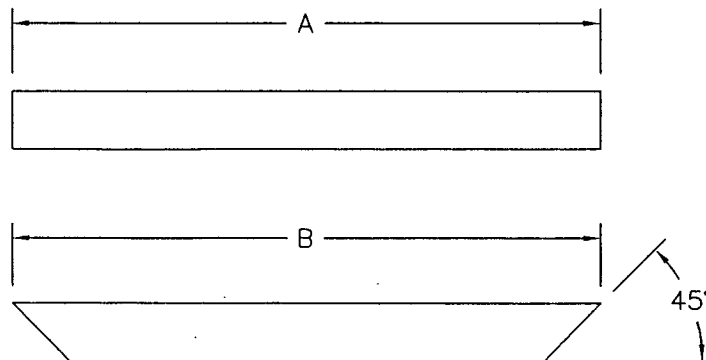
PRELIMINARY ISSUE

DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3516	REV. A SHEET 1 OF 3
DATE 06.05.08		TITLE BASKET BASE ASSEMBLY (A119) SCALE NTS	
A	06.05.08	NEW ISSUE	

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PARTS LIST FOR D3516-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3516-1	2	—	102.00	RIB
D3516-3	2	—	25.50	RIB
D3516-5	8	26.75	—	RIB
D3516-7	3	45.50	—	RIB
D3516-9	4	N/A	N/A	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRKT
D3348-1	4	N/A	N/A	CLEVIS
D3442-1	2	N/A	N/A	SHIM



NOTES:

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
- 3) MESH MATERIAL: 3/4-16F EXPANDED SS
- 4) WELD PER DART QSI 004
- 5) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

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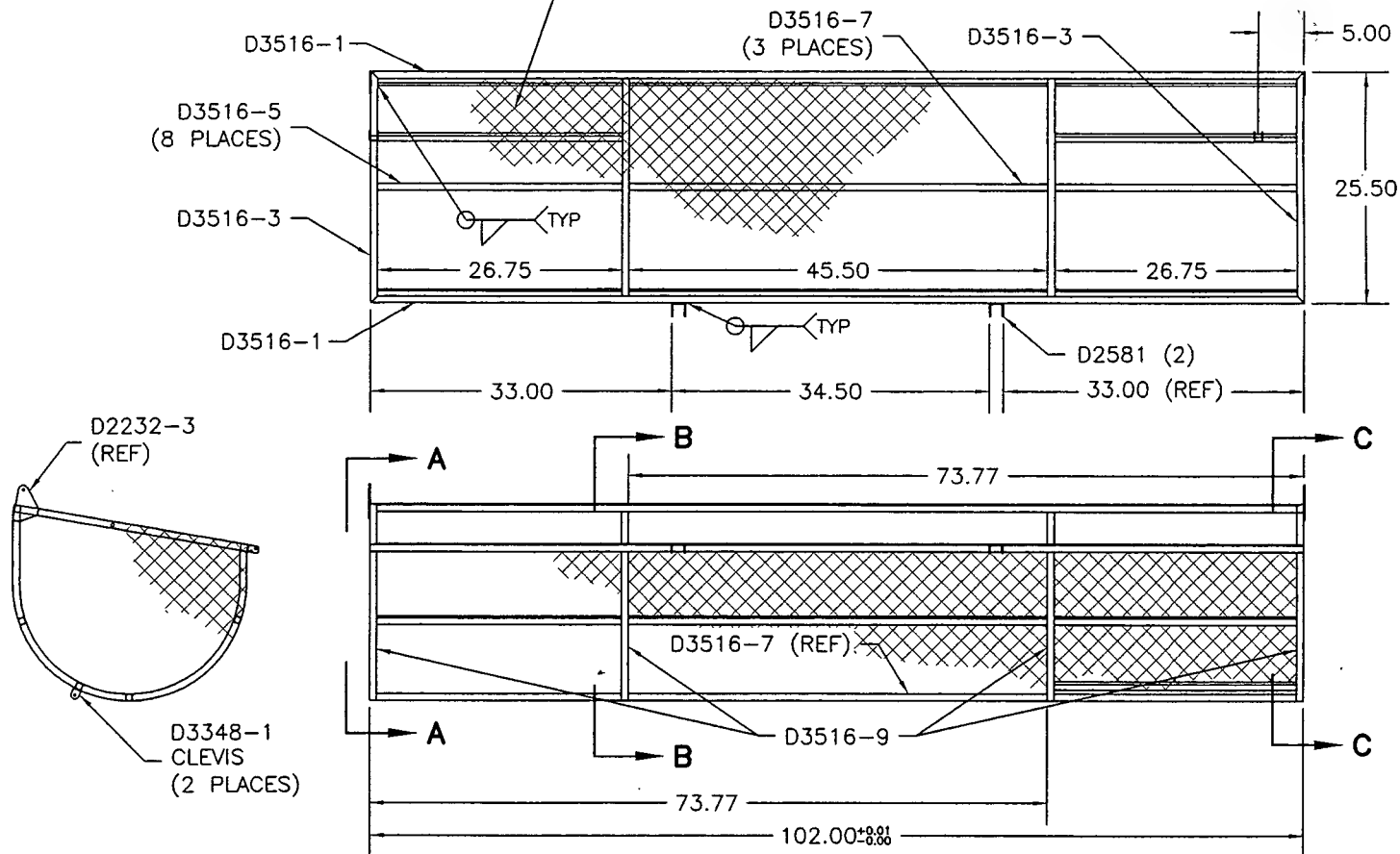
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048A

PRELIMINARY ISSUE

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SKIN INSIDE SURFACE OF
 BASKET WITH MESH.
 TACK WELD EACH END OF
 STRAND TO FRAME



D3516 BASKET BASE ASSEMBLY

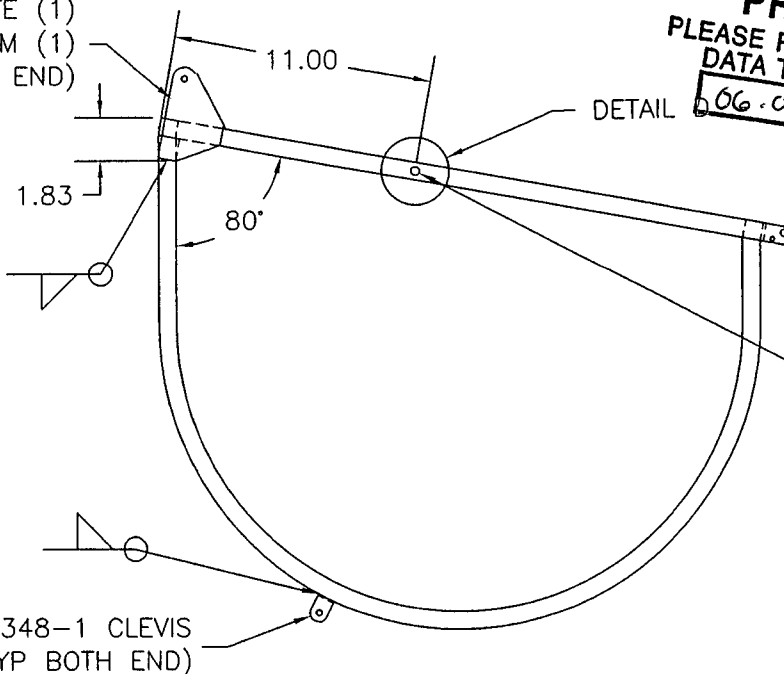
MESH MATERIAL: 3/4-16F EXPANDED SS
 FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2)
 PER DART QSI 005 4.3

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DATE	TITLE	REV. A
06.05.08	BASKET BASE ASSEMBLY (A119)	SHEET 2 OF 3
		SCALE
		1:20

PRELIMINARY ISSUE

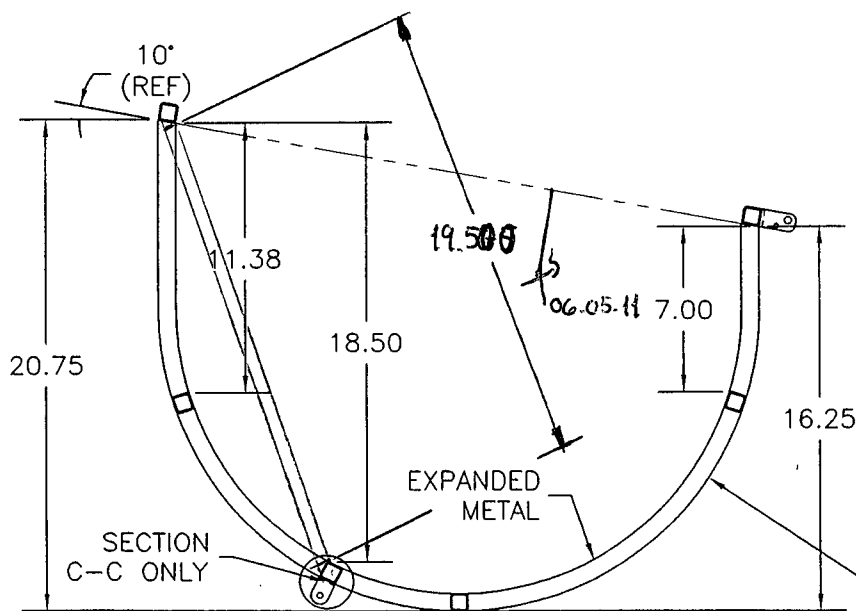
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3516	REV. A SHEET 3 OF 3
DATE 06.05.08		TITLE BASKET BASE ASSEMBLY (A119)	SCALE 1:8

D2232-3 HINGE PLATE (1)
D3442-1 SHIM (1)
(TYP BOTH END)

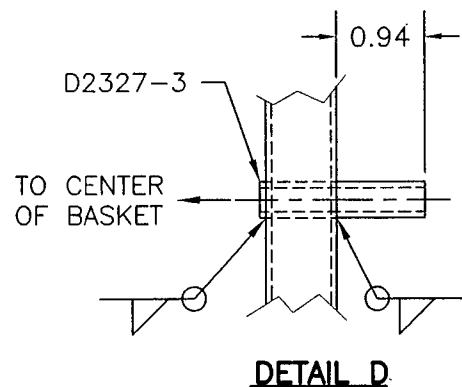


SECTION A-A:
SPACER DETAIL

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SECTION B-B AND SECTION C-C:
RIB DETAIL



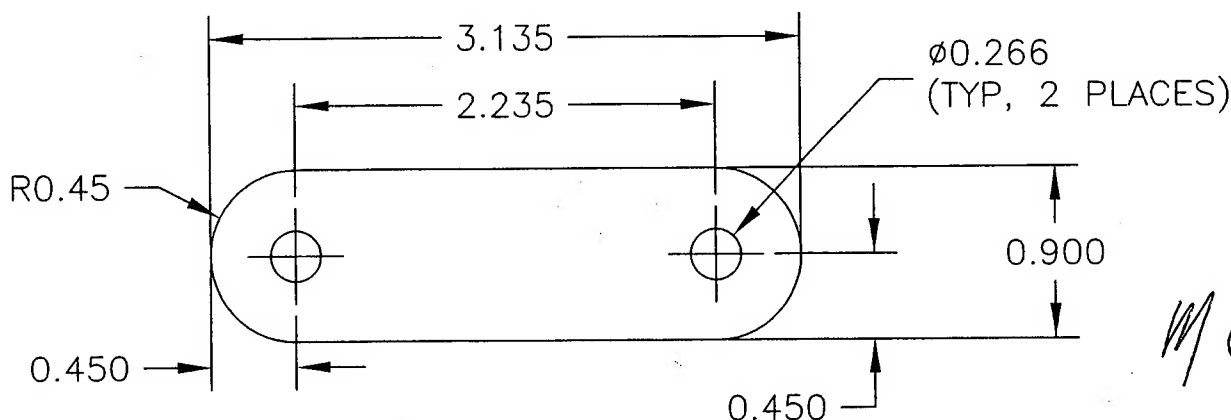
DETAIL D

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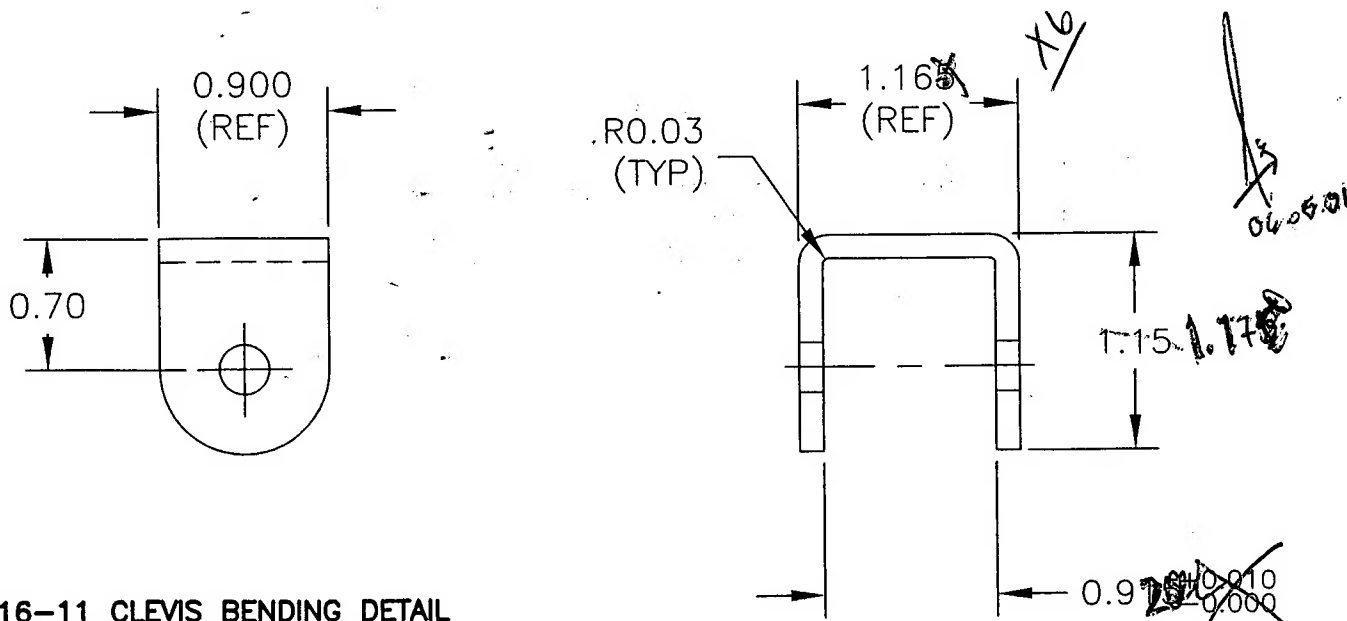
PRELIMINARY ISSUE
06.05.08

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CHECKED	APPROVED	DRAWING NO. D3516	REV. A SHEET 4 OF 4
DATE 06.05.08		TITLE BASKET BASE ASSEMBLY (A119)	SCALE 1:1



D3516-11F CLEVIS FLAT PATTERN

- 1) MATERIAL: AISI-304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)



D3516-11 CLEVIS BENDING DETAIL

- 1) MATERIAL: MAKE FROM D3516-11F
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	3516-11
Inspection Dwg:	Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

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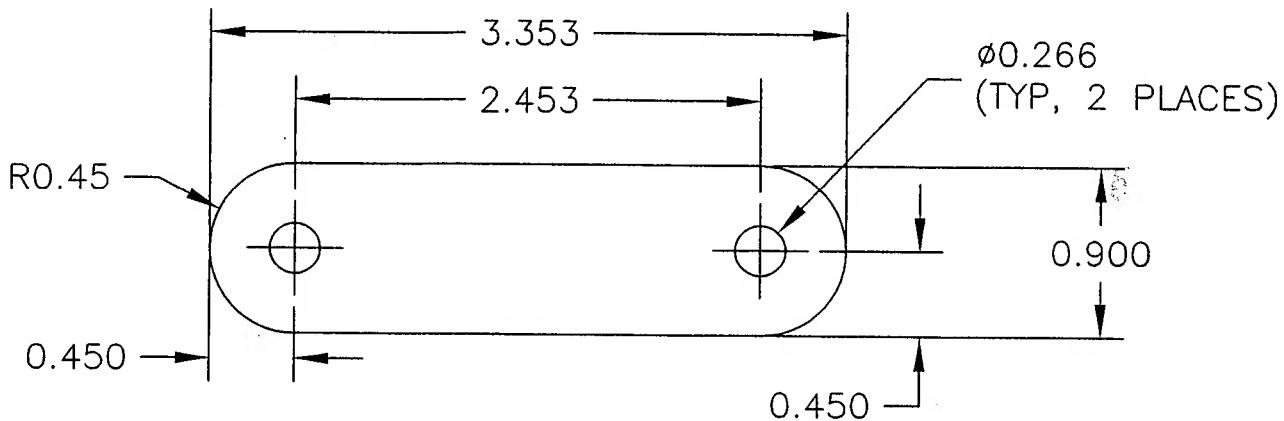
Measured by:	<i>mm</i>	Audited by:	<i>EE</i>	Prototype Approval:	<i>h</i>
Date:	06.05.31	Date:	06.05.31	Date:	06.07.31

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

PRELIMINARY

06.05.25

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DATE 06.05.08		TITLE BASKET BASE ASSEMBLY (A119)	SCALE 1:1



D3516-11F CLEVIS FLAT PATTERN

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAGE (0.063 THICK) (REF. DART SPEC. M304S16GA)

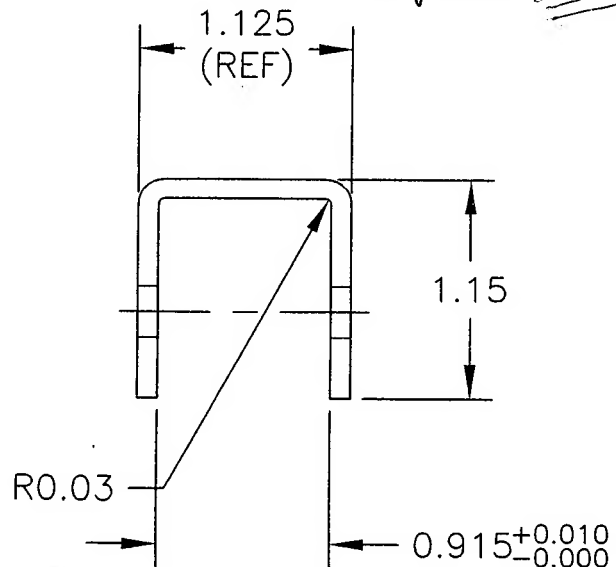
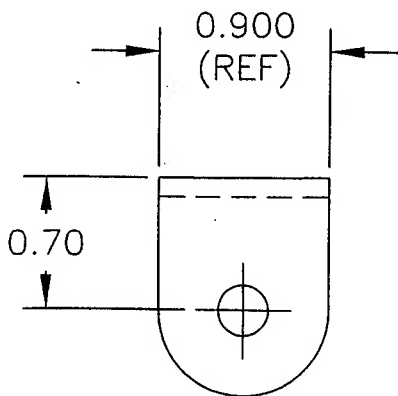
M19052

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X 6



D3516-11 CLEVIS BENDING DETAIL

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